

Fig.1 (a)

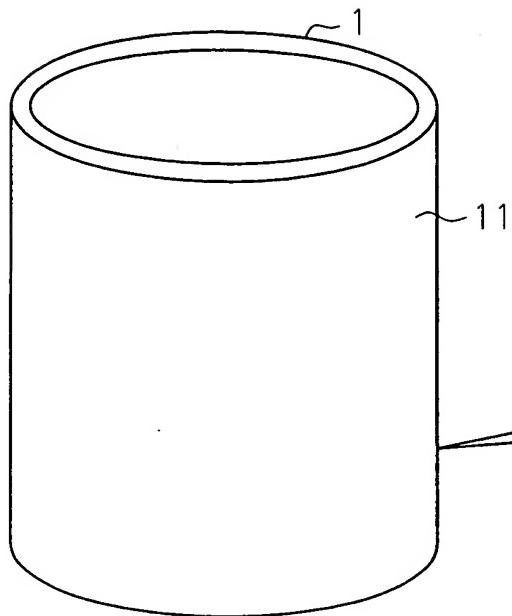


Fig.1 (b)

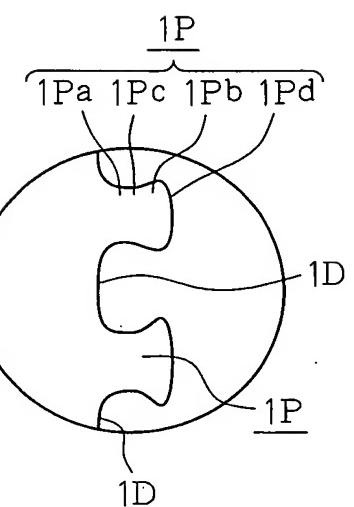


Fig.1 (c)

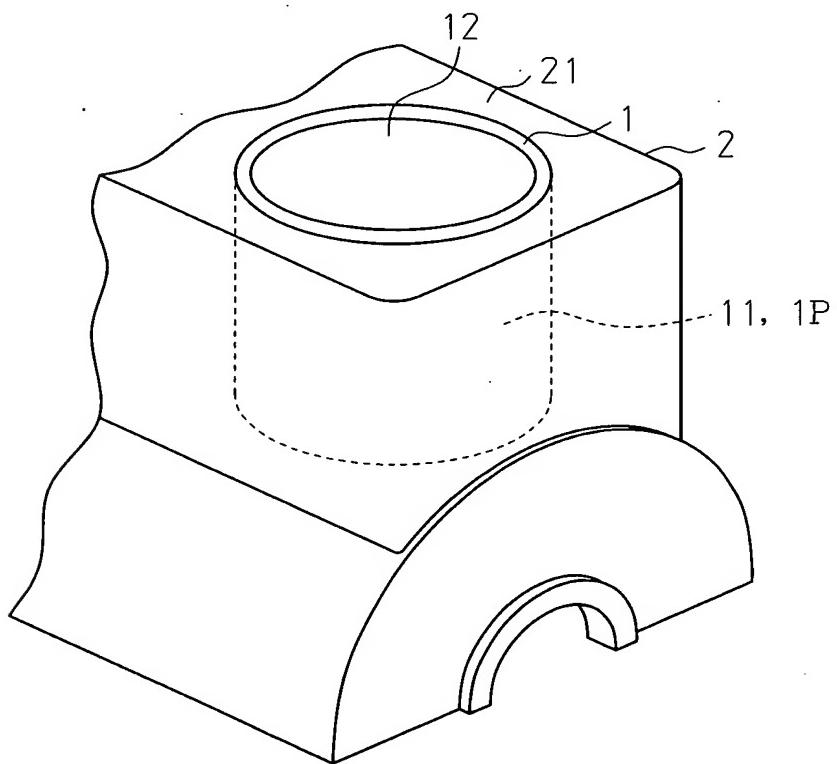


Fig.2

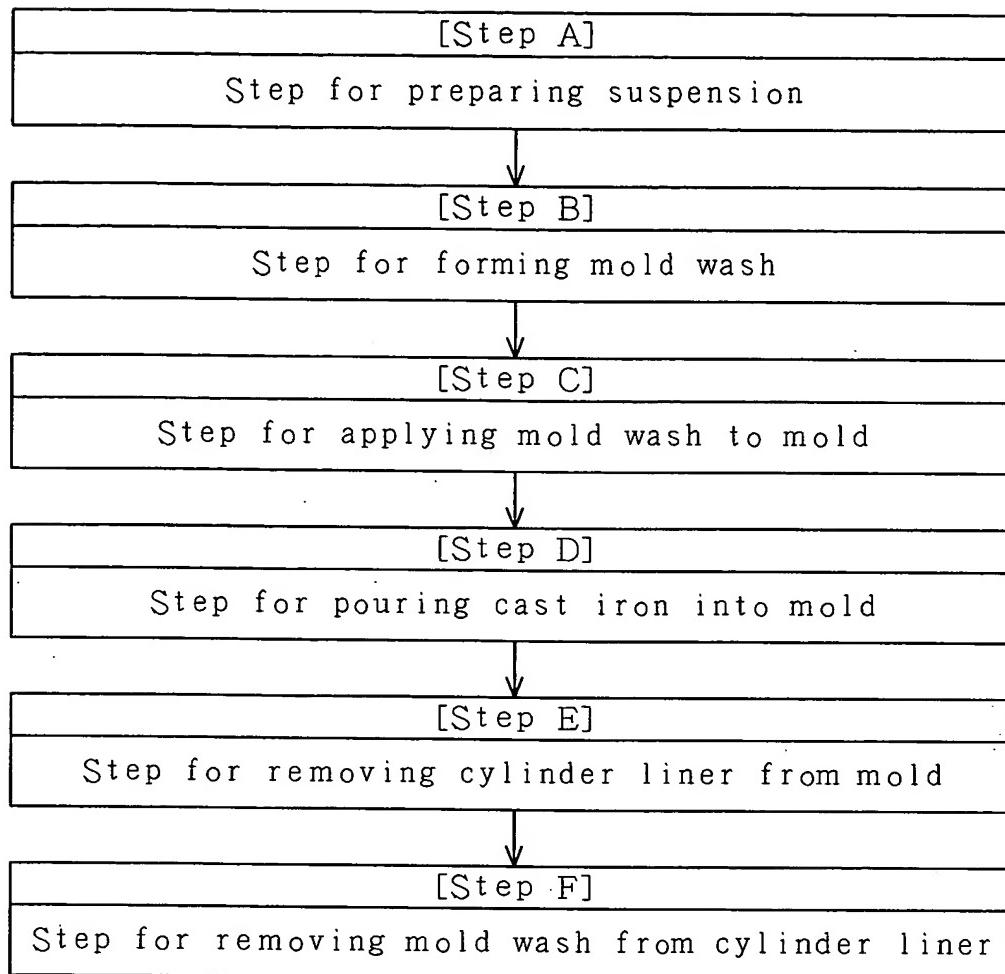


Fig.3

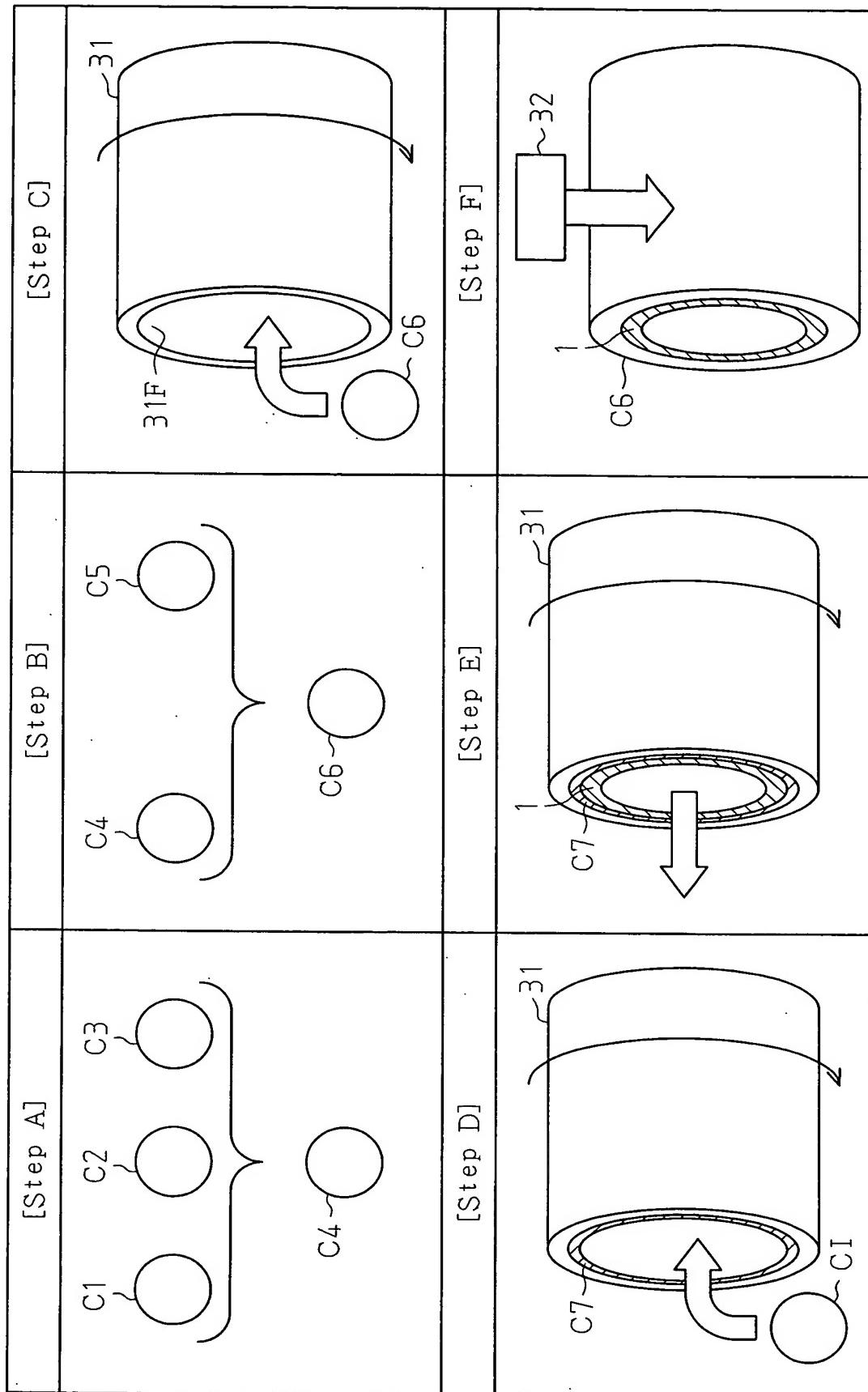


Fig.4

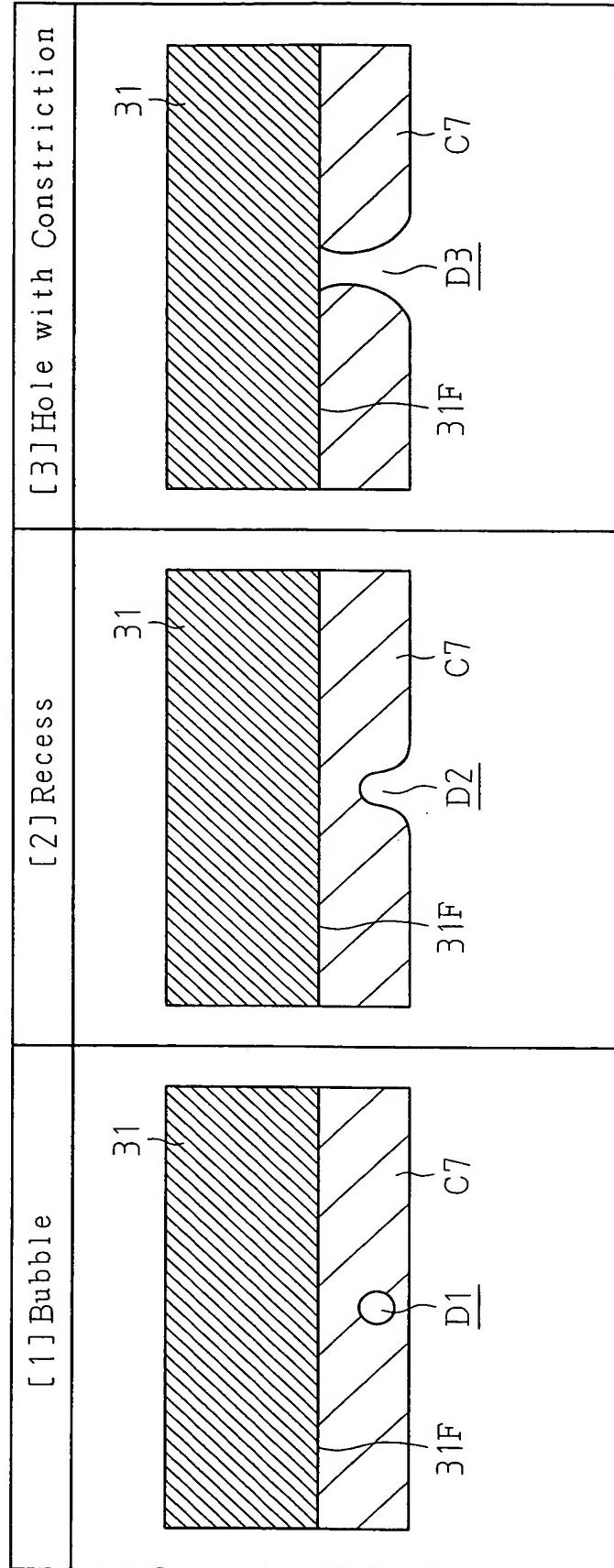


Fig.5 (a)

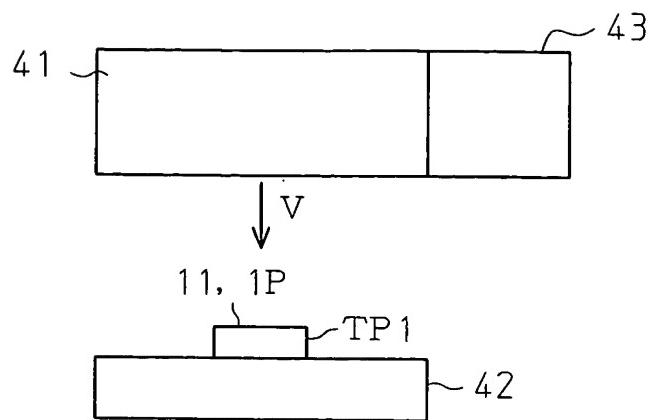


Fig.5 (b)

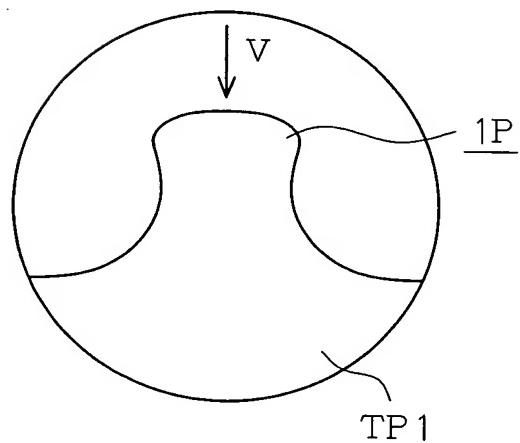


Fig.6(a)

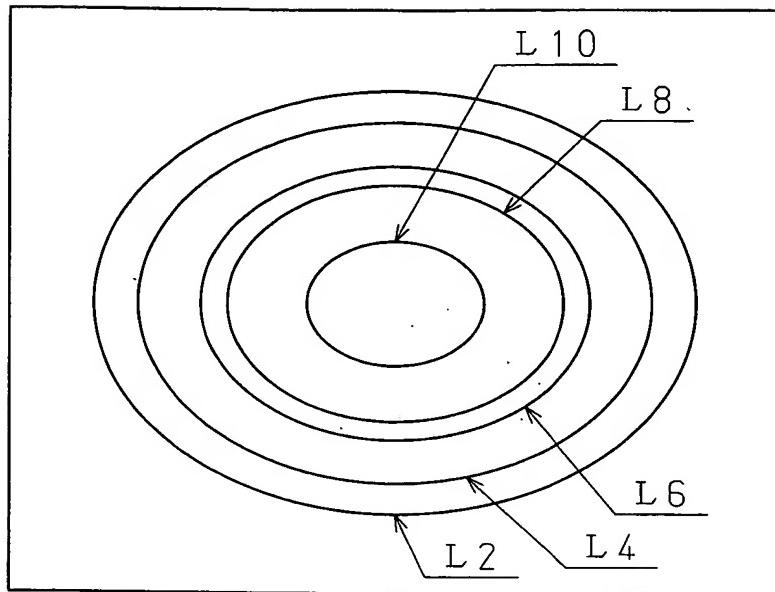


Fig.6(b)

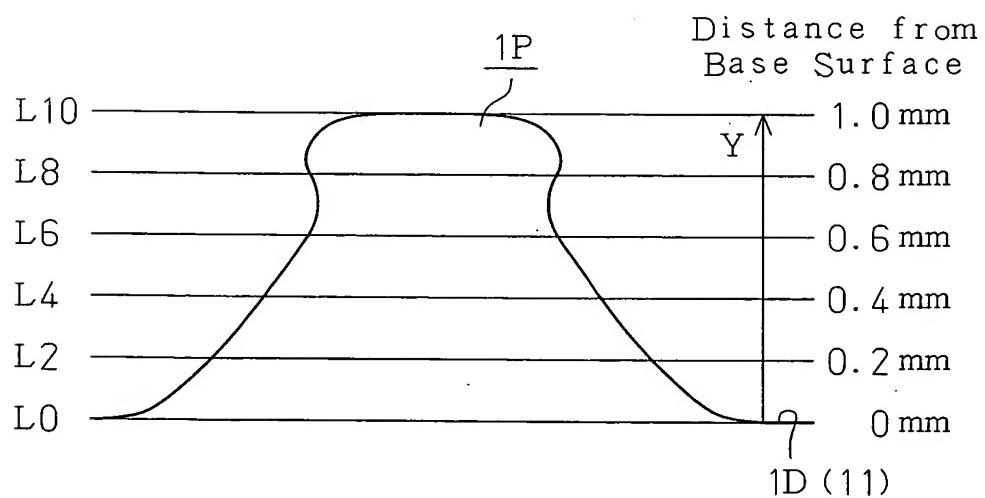


Fig.7 (a)

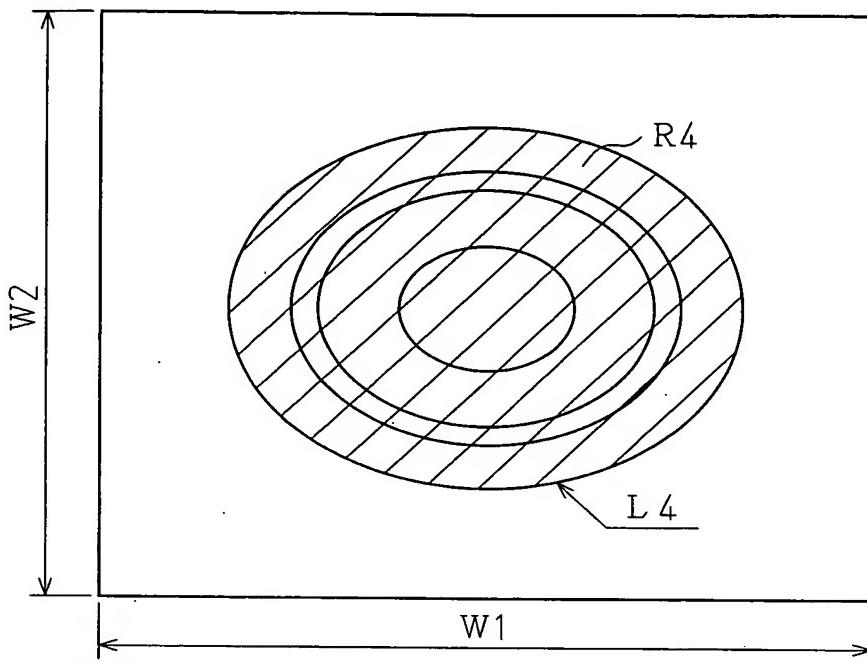


Fig.7 (b)

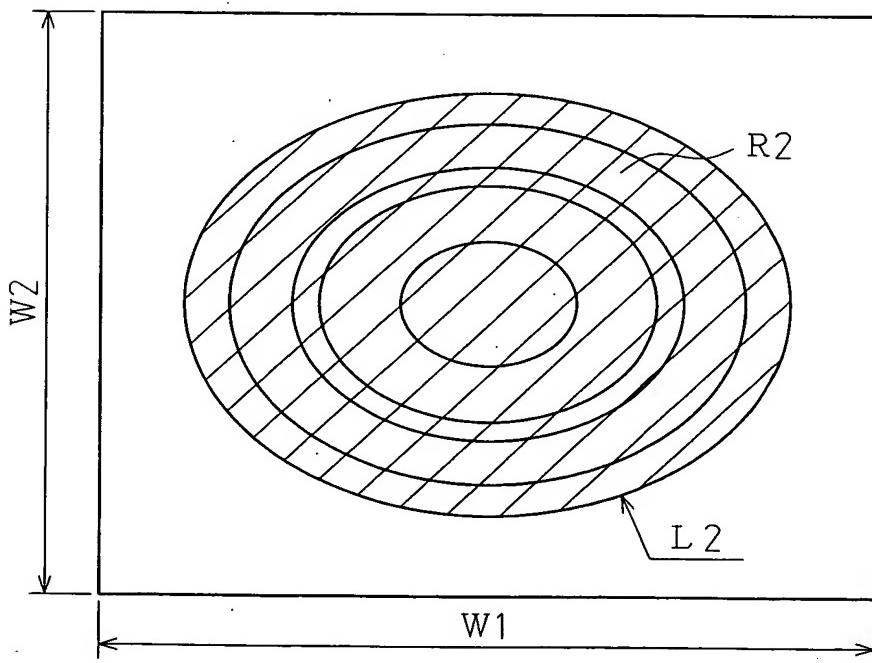


Fig.8

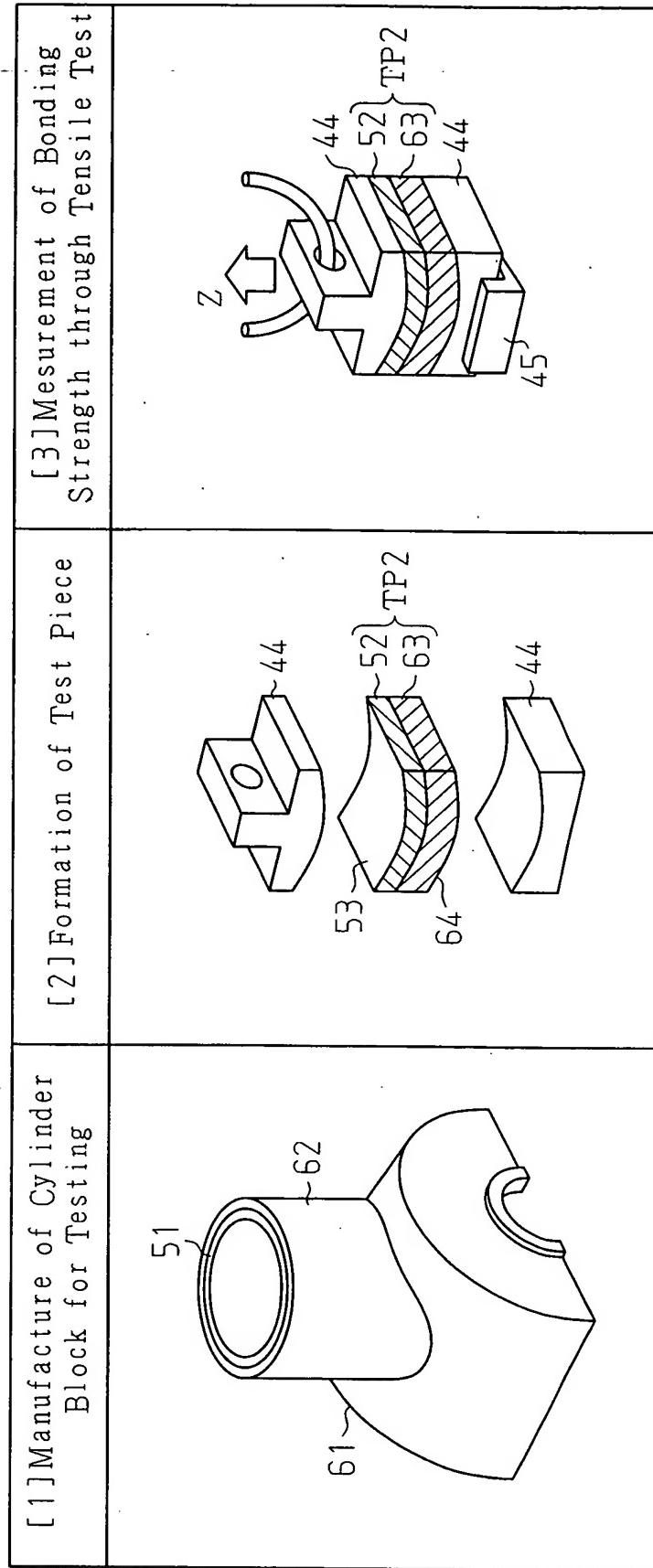


Fig.9

Conditions for Die-Casting		
Aluminum Material	ADC 12	
Casting Pressure	55	[MPa]
Castiong Speed	1.7	[m/s]
Molten Metal Temperature	670	[°C]
Cylinder Thickness (Aluminum Material)	4.0	[mm]

Fig.10

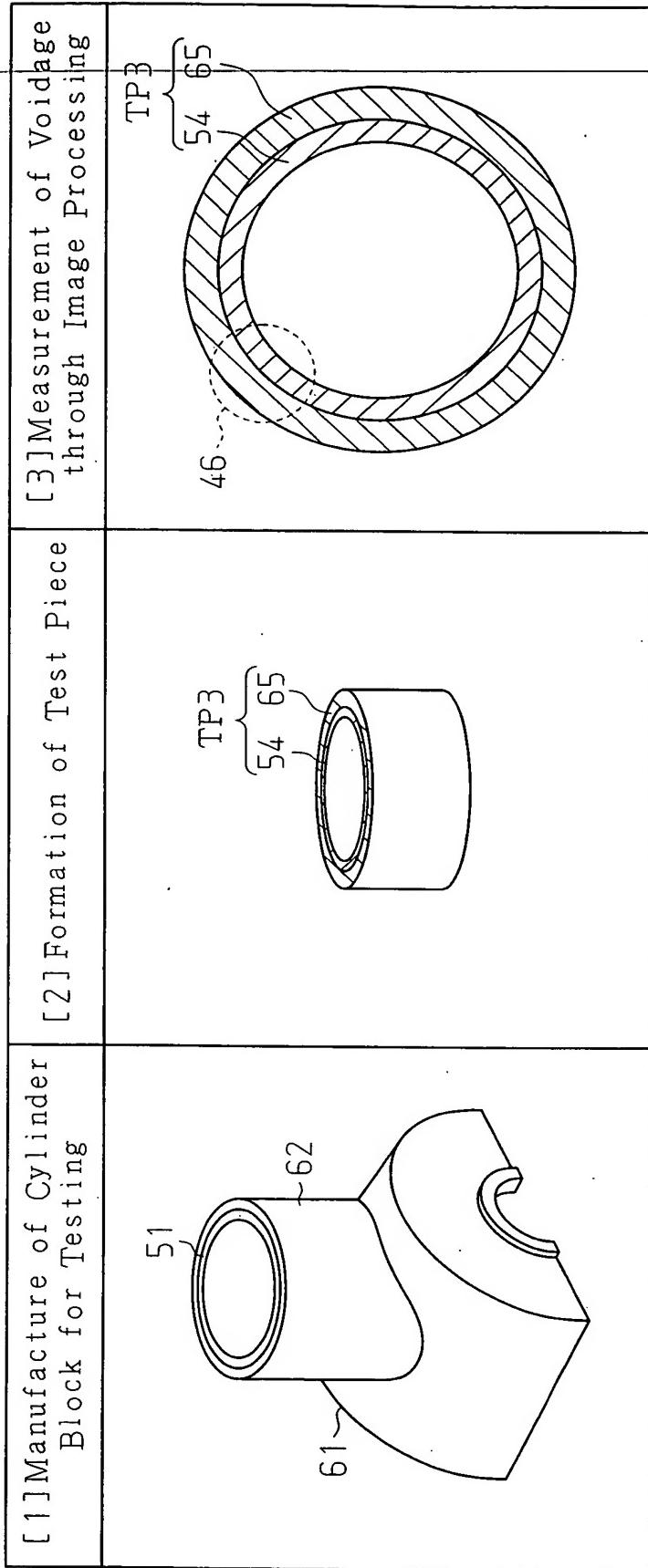


Fig.11

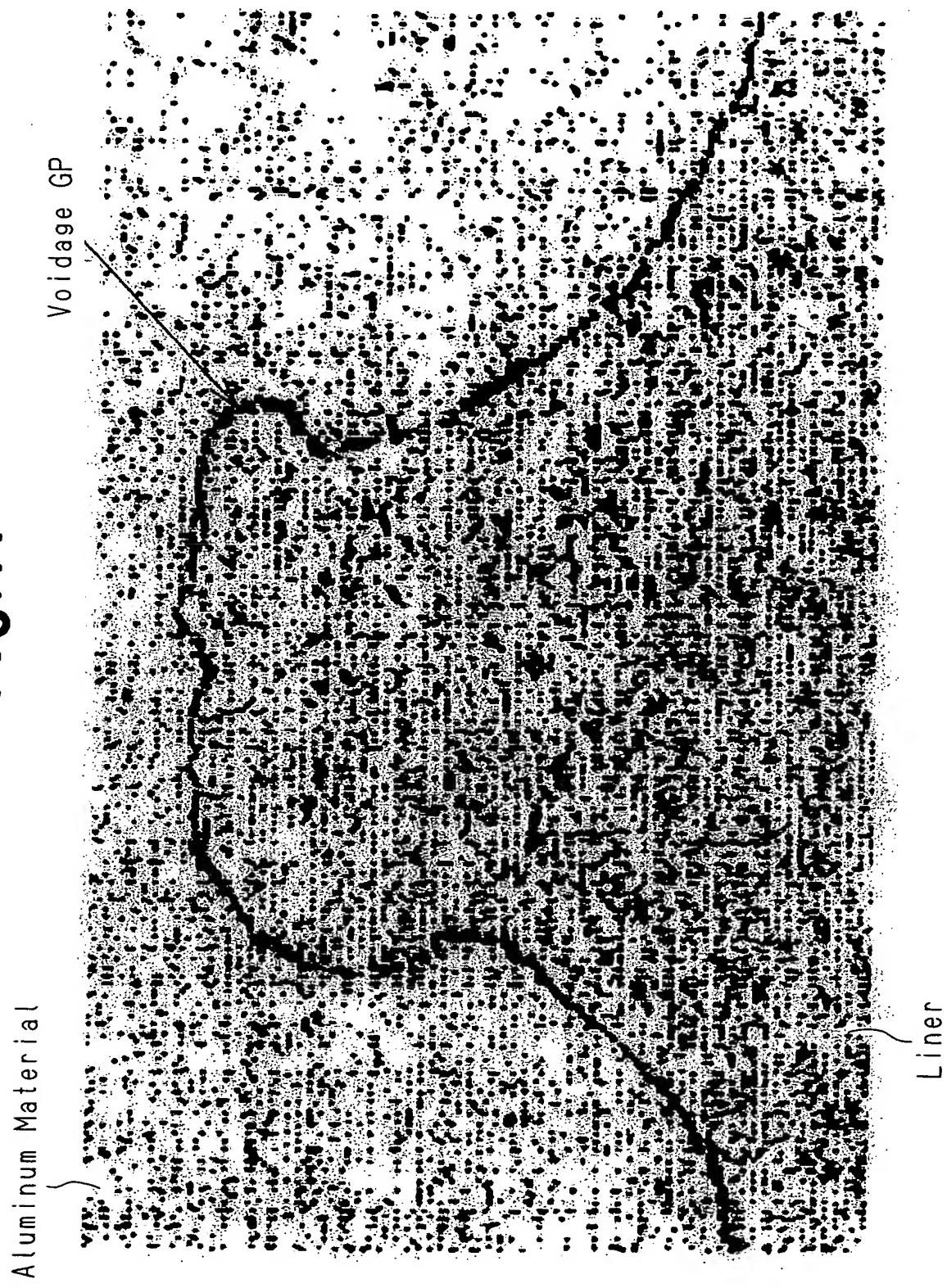


Fig.12

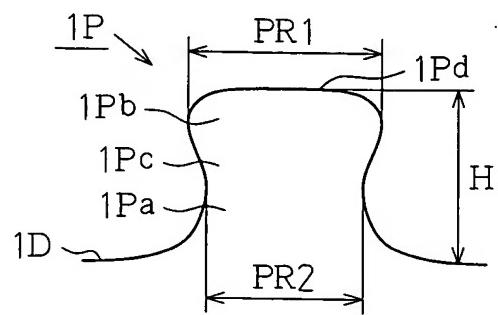


Fig.13

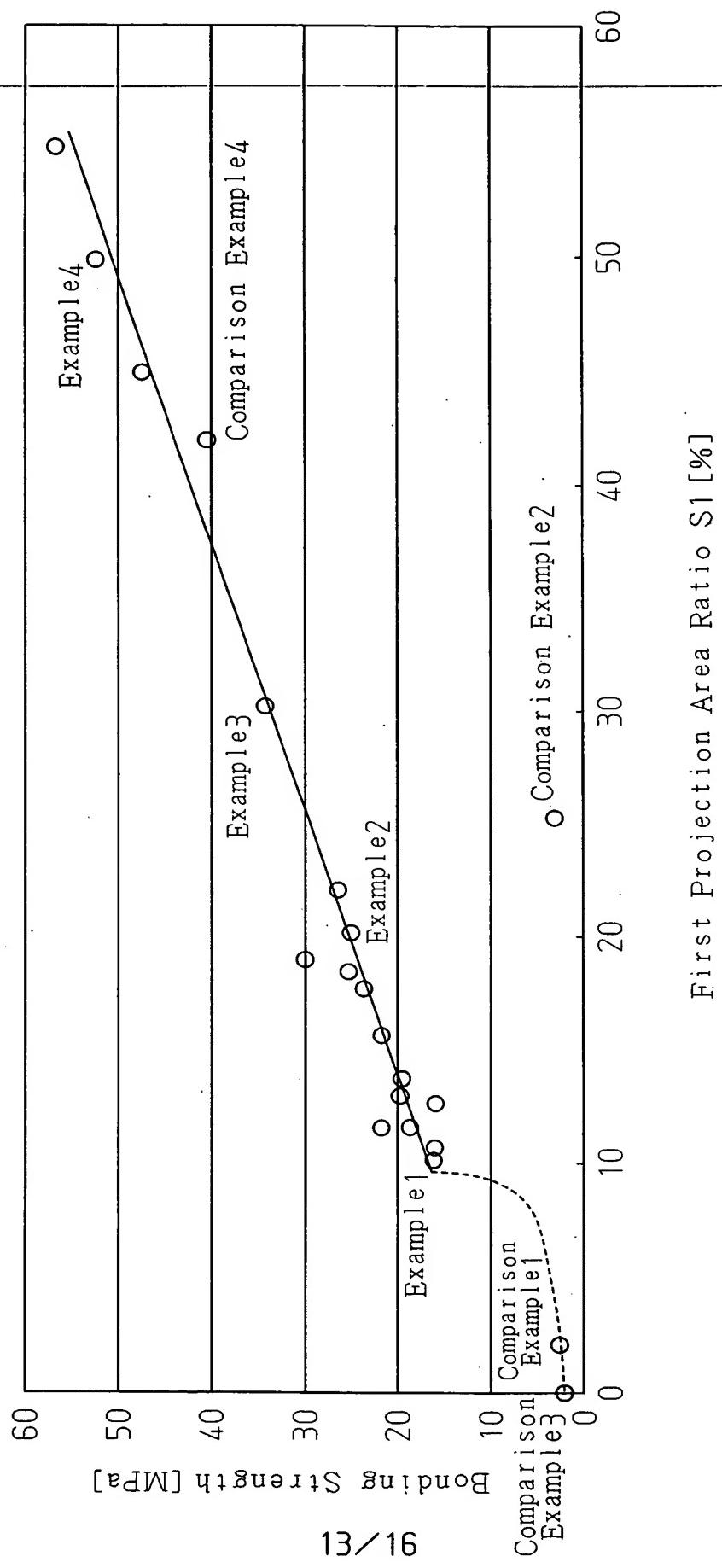


Fig. 14

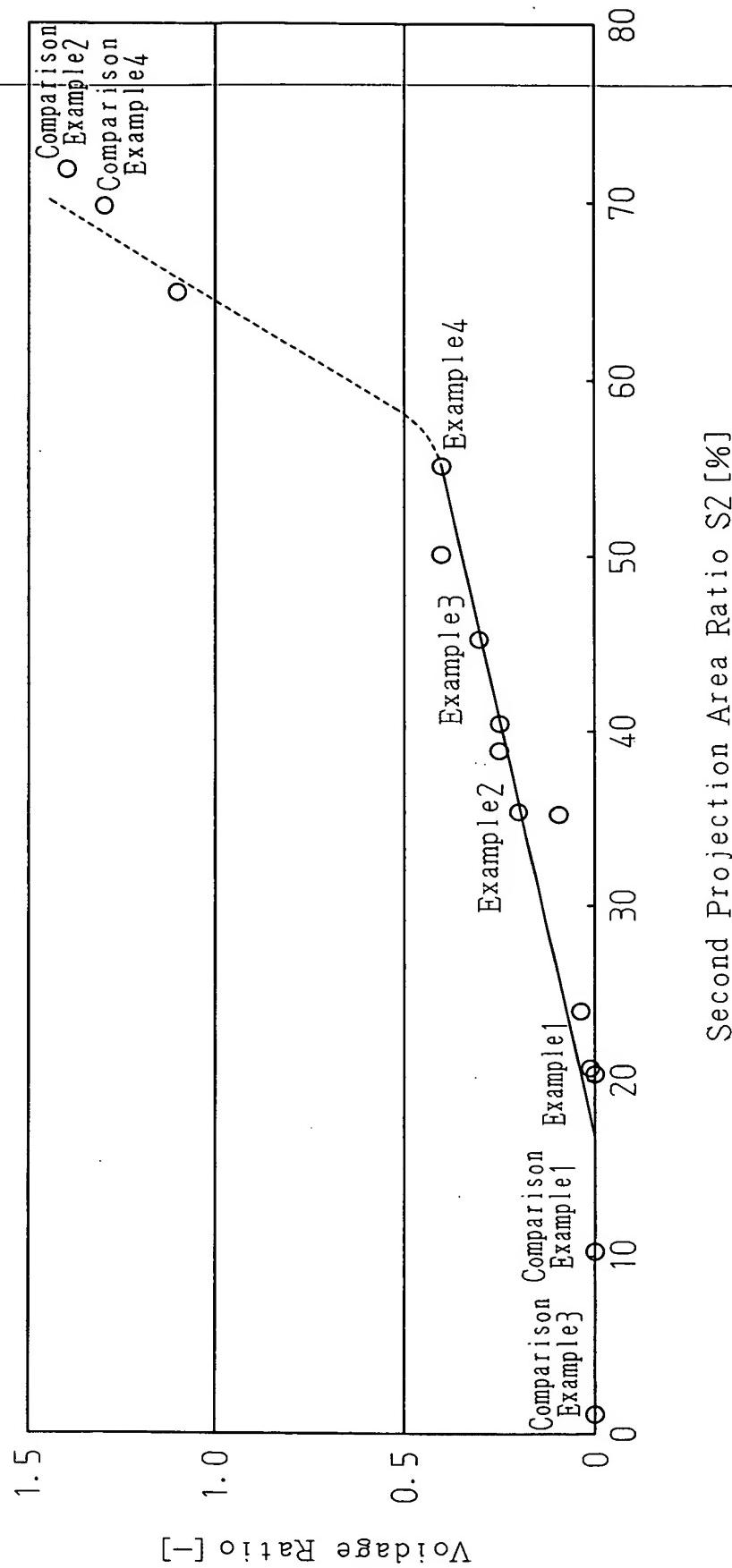
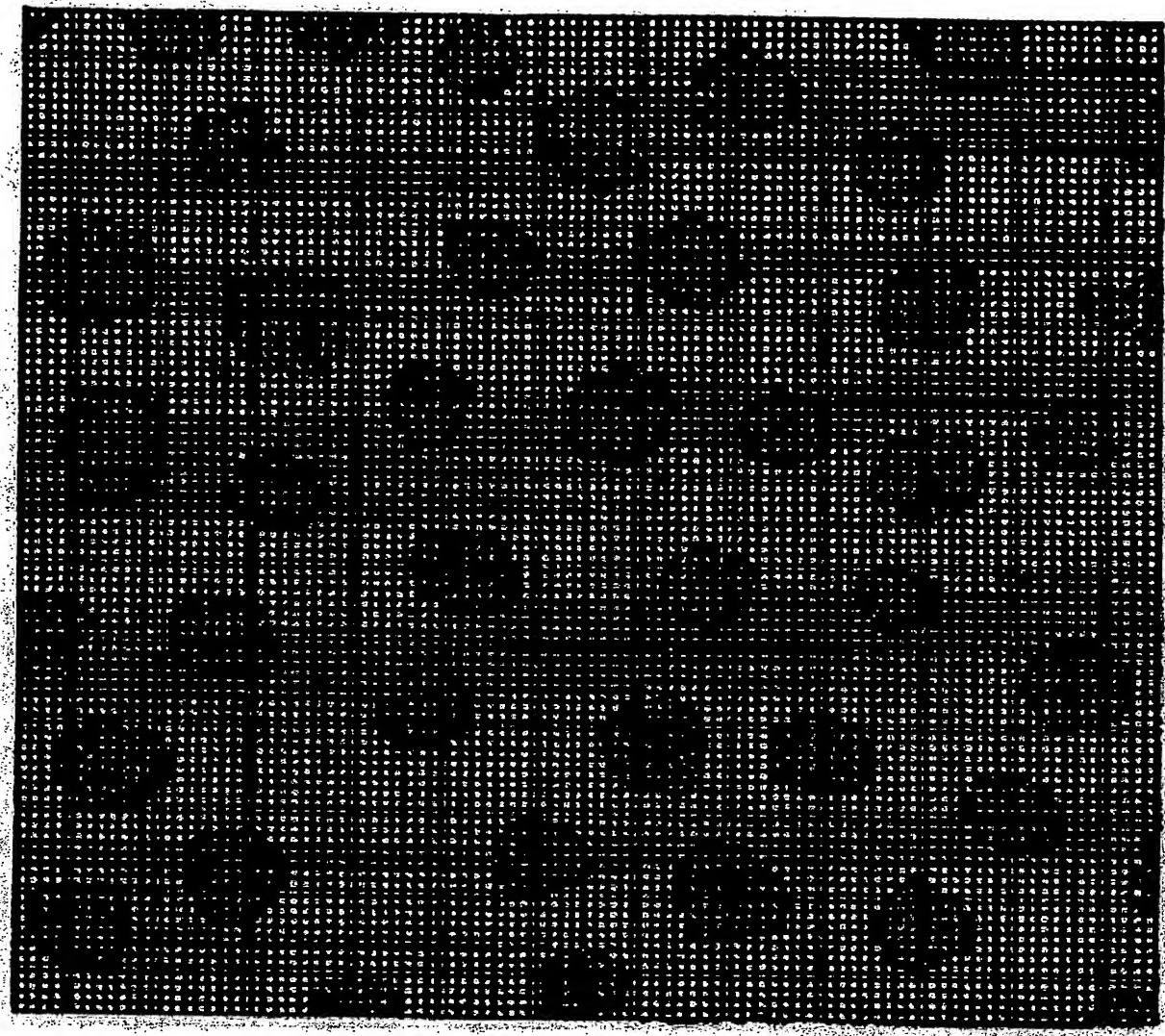
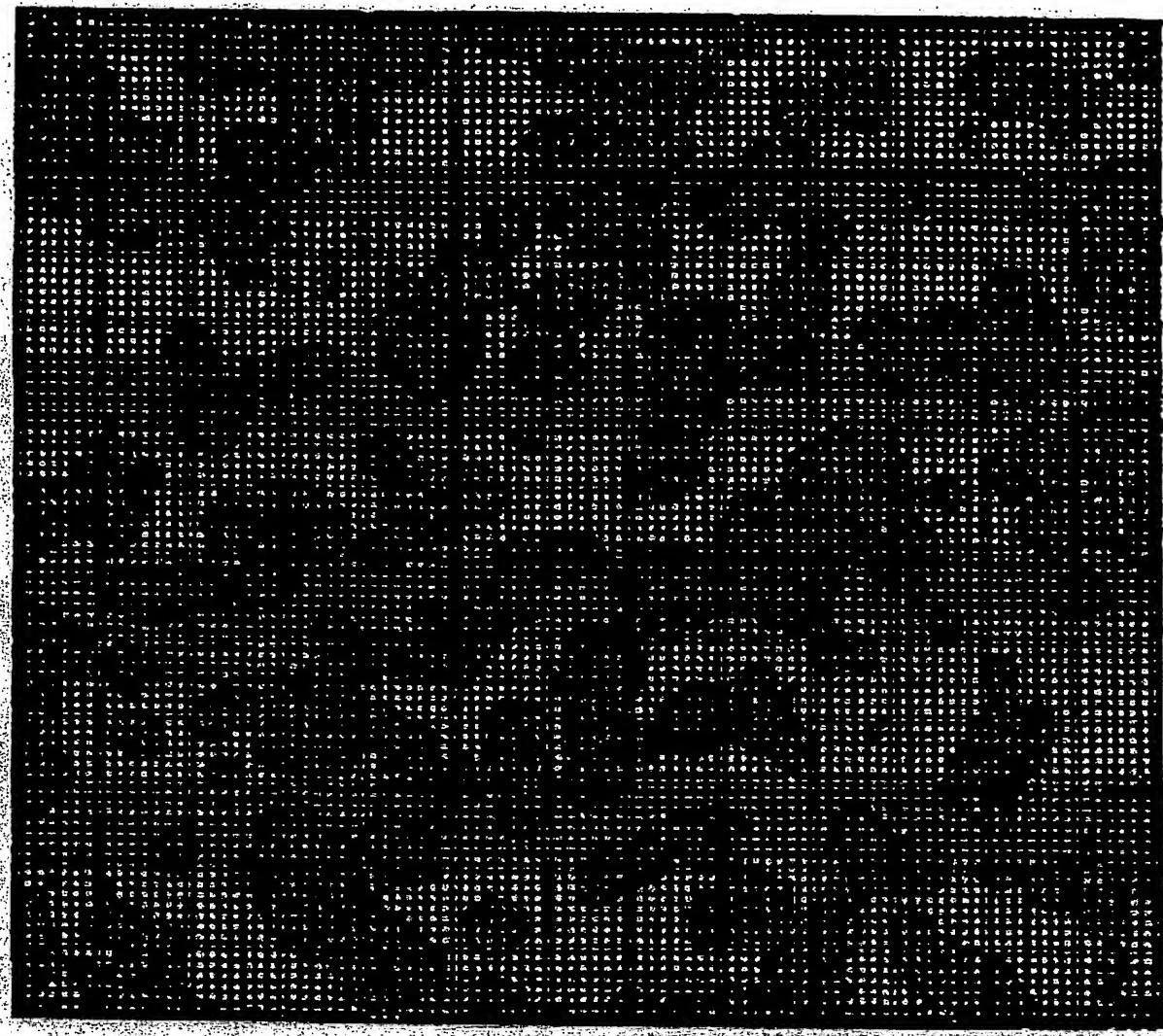


Fig.15



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Fig.16



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